

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011786**Date Inspected:** 01-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

TRIAL ASSEMBLY YARD**ULTRASONIC INSPECTION****OBG SEGMENT 6AW - 6BW**

This Quality Assurance (QA) Inspector performed conventional UT (Ultrasonic Testing) in conjunction with ABF Ultrasonic Testing (UT) department for detection of planar transverse indication.

Ultrasonic Testing (UT) performed on repair areas of the counter weight side edge panel splice weld between OBG segment 6AW and 6BW (OBW6-001) utilizing scanning pattern A, B, C and D (Fig 6.7). During the Ultrasonic Testing (UT) ABF inspectors found 8 transverse linear indications. American Bridge Fluor (ABF) request number was 01312010-3.

TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress.

WELDING INSPECTION REPORT

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OBG SEGMENT 6EAST

This Quality Assurance (QA) Inspector observed ZPMC qualified welders 054016, 048047, 049339 performing Shielded Metal Arc Welding process for the weld CA030-004 located on weld between edge panel and deck panel (bike path side). ZPMC QC Mr. Zhang Qiang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F)-FCM- Repair-1. Critical weld report identified T-CWR1139.

OBG SEGMENT 7AW – 7BW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067079 performing Flux Cored Arc Welding process for the weld OBW7-001 located on deck panel splice weld between OBG segment 7AW and 7BW. ZPMC QC Mr. Zhang Hui Tun monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-223(2)1-T-2.

This Quality Assurance (QA) Inspector observed ZPMC qualified welders 066746, 066673 performing Flux Cored Arc Welding process for the weld OBW7-002 located on deck panel splice weld between OBG segment 7AW and 7BW. ZPMC QC Mr. Zhang Hui Tun monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-223(2)1-T-2.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 045280 performing Flux Cored Arc Welding process for the weld OBW7-003 located on deck panel splice weld between OBG segment 7AW and 7BW. ZPMC QC Mr. Zhang Hui Tun monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-223(2)1-T-2.

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Utekar,Shrikant
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Quality Assurance Inspector

Reviewed By:	Dawson,Paul
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QA Reviewer
